

AMENDMENTS TO THE CLAIMS:

This listing of claims will replace all prior versions, and listings, of claims in the application:

LISTING OF CLAIMS:

1. (original) Form-fill-seal machine for making bag-shaped packagings for products, such as edible products, from a web of foil material, such as synthetic foil, the machine comprising a frame having a stock of web of foil material and a supply of the web of foil material in flat condition, and a form-fill unit positioned at a front side of the machine, wherein the form-fill unit comprises a form shoulder for transforming the flat web of foil material into a foil tube, as well as a form-fill tube connecting to the form shoulder, having a vertical main plane of section, in which the machine furthermore comprises transverse sealing jaws that are positioned below the lower end of the fill tube for forming transverse seals in the foil tube and which are reciprocally moveable in a vertical plane perpendicular to the front side of the machine and the said vertical plane of section, the form shoulder being asymmetrically shaped for forming an overlap in the foil tube which extends to at least a short distance from or near the said vertical plane of section, wherein the machine is furthermore provided with first longitudinal sealing means that are positioned at a first side, at one lateral side of the form tube, as considered from the front side of the

machine, preferably at a short distance from or near the said vertical plane of section, for forming a first, severable longitudinal seal at the location of the overlap.

2. (original) Form-fill-seal machine according to claim 1, furthermore provided with second longitudinal sealing means positioned at a second side, at one lateral side of the form tube, as considered from the front side of the machine, opposite the first side, for forming at least one longitudinal seal in the foil tube.

3. (original) Form-fill-seal machine according to claim 2, wherein two longitudinal sealing means are provided that are positioned at either side of, preferably equidistant from, the vertical plane of section.

4. (original) Form-fill-seal machine according to claim 3, wherein the form-fill unit at the second side is provided with two protruding form strips for forming longitudinal folds in the foil tube, wherein the second longitudinal sealing means are positioned for sealing the longitudinal folds.

5. (original) Form-fill-seal machine according to claim 4, wherein second longitudinal sealing means comprise an

anvil/form member, that extends between both longitudinal folds for positioning them for sealing.

6. (original) Form-fill-seal machine according to claim 1, wherein the position of at least one of the first and second longitudinal sealing means is adjustable in a direction towards/away from the fill tube.

7. (original) Form-fill-seal machine according to claim 5, wherein the anvil/form member forms an interchangeable part.

8. (original) Form-fill-seal machine according to claim 1, wherein the form-fill unit is detachably placed in the machine.

9. (original) Form-fill-seal machine according to claim 1, wherein the form/fill tube at the first side at the lower end is provided with a first protrusion, situated in or near the vertical plane of section and extending downwards, and which in horizontal direction is free from the remainder of the lower end of the fill tube.

10. (original) Form-fill-seal machine according to claim 9, wherein the first protrusion is pen- or lip-shaped.

11. (original) Form-fill-seal machine according to claim 9, wherein the first protrusion with its end extends beyond the profile of the fill tube.

12. (original) Form-fill-seal machine according to claim 9, wherein the form/fill tube at its lower end is furthermore provided with at least a second protrusion, which is at least situated at the second side and defines a recess with the first protrusion.

13. (original) Form-fill-seal machine according to claim 12, wherein the second protrusion forms a sharp guiding edge, particularly substantially oriented towards the bottom.

14. (original) Form-fill-seal machine according to claim 12, wherein two second protrusions are present, which extend on either side of the vertical plane of section and preferably keep an area free between them, in which area a fold-maker is able to extend, wherein the two second protrusions preferably are connected to each other by a plate, for instance a V-shaped plate, which is forming a cavity for the inwardly folded bottom area to be made.

15. (original) Form-fill-seal machine according to claim 1, wherein the fill tube has a substantially rectangular cross-

section, having the main sides substantially parallel to the vertical plane of section.

16. (original) Form-fill-seal machine according to claim 15, wherein the first side of the form and fill tube is bent having a flat surface between bent transitions to the main sides.

17. (original) Form-fill-seal machine according to claim 1, furthermore provided with means for arranging a strip of doublesided adhesive tape on the web of foil material in the area of the intended overlap.

18. (original) Form-fill-seal machine according to claim 17; wherein the first longitudinal sealing means are positioned for arranging the severable longitudinal seal at the side of the strip of doublesided adhesive that faces away from the outer longitudinal edge of the overlap.

19. (original) Form-fill-seal machine for making bag-shaped packagings for products, such as edible products, from a web of foil material, such as synthetic foil, the machine comprising a frame having a stock of web of foil material and a supply of the web of foil material in flat condition, and a form-fill unit positioned at the front side of the machine, wherein the form-fill unit comprises a form shoulder for transforming the flat

web of foil material into a foil tube, as well as a form-fill tube connecting to the form shoulder, having a vertical main plane of section, in which the machine furthermore comprises transverse sealing jaws that are positioned below the lower end of the fill tube for forming transverse seals in the foil tube and which are reciprocally moveable in a vertical plane perpendicular to the front side of the machine and said vertical plane of section, the form shoulder being asymmetrically shaped for forming an overlap in the foil tube which extends from a front side of the form tube to in a first lateral side, wherein the machine is furthermore provided with first longitudinal sealing means positioned near said first side, at one lateral side of the form tube, as considered from the front side of the machine, for forming a first, severable longitudinal seal at the location of the overlap.

20. (original) Form-fill-seal machine according to claim 19, wherein the overlap ends at the first side at at least a short distance from or near the said vertical plane of section.

21. (original) Form-fill-seal machine according to claim 20, wherein the first longitudinal sealing means are positioned at a short distance from or near the said vertical plane of section.

22. (original) Form-fill-seal machine for making bag-shaped packagings for products, such as edible products, from a

web of foil material, such as synthetic foil, the machine comprising a frame having a stock of web of foil material and a supply of the web of foil material in flat condition, and having a form-fill unit, the form-fill unit comprising an asymmetrical form shoulder for transforming the flat web of foil material into a foil tube, while forming an overlap, as well as a form-fill tube connecting to the form shoulder, which tube has a substantially rectangular cross-section and which is positioned in the machine having a first main side facing away from the machine and a second main side facing the machine, wherein the form shoulder is designed for forming the overlap at at least the first or second main side, wherein the form-fill unit at a first short side of the form-fill tube is provided with two protruding form strips for forming longitudinal folds in the foil tube, wherein the form-fill unit is furthermore provided with first longitudinal sealing means for forming a first, severable longitudinal seal in the area of the overlap and with second longitudinal sealing means for forming second longitudinal seals at the location of the longitudinal folds, wherein the form-fill-seal machine is furthermore provided with means for applying a strip of doublesided adhesive tape on the web of foil material in the area of the intended overlap, wherein the form-fill-seal machine is furthermore provided with transverse sealing means positioned below the fill-form unit for forming transverse seals in the foil tube and with means for severing them at the location of the transverse seals.

23. (original) Form-fill-seal machine according to claim 22, wherein the means for arranging the severable seal are positioned for arranging the severable seal at the side of the strip of doublesided adhesive facing away from the outer longitudinal edge of the overlap.

24. (original) Form-fill-seal machine according to claim 22, wherein the second longitudinal sealing means are positioned at the second short side of the form-fill tube.

25. (original) Form-fill-seal machine according to claim 22, wherein the first short side of the form-fill tube is bent having a flat surface between bent transitions to the main sides.

26. (original) Form-fill-seal machine according to claim 22, wherein the form-fill unit is detachably arranged on the frame.

27. (original) Form-fill-seal machine according to claim 22, wherein the first longitudinal sealing means and/or the second longitudinal sealing means are detachably arranged on the frame.

28-48. (canceled)



49. (original) Form-fill-seal machine according to claim 1, designed as a continuously operative machine.

50. (original) Form-fill-seal machine according to claim 1, designed as a step-wise or discontinuously operative machine.